

Work Order ID 63861

Wednesday, November 17, 2010 10:25:30 A



Page 1

Item ID: D212-664-101TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 11/17/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

10/11/17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D212-664-141

Rev D

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA113
2-Turn first side as per Folio FA113
3-File down transition lines smooth.

SA 10/12/02

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

SA 10/12/02

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA113
2-File down transition lines smooth.
3-Remove sand and plugs

SA 10/12/02

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|-----------------------------|--|----------------|---------------------------|---------------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 10.12.06 | ND | Some O.D.'s over tol by ≈ 0.005 . OD near cuff under tol. by 0.004 | CP 10.12.07 DSI 642 | Acceptable. BENDING moments near cuff are negligible | | | CP 10.12.07 DSI 642 | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 63861

Wednesday, November 17, 2010 10:25:30 A

Page 2

Item ID: D212-664-101TRN

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Revision ID:

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Start Date: 11/17/2010 Start Qty: 1.00

Required Date: 11/30/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|-------------------------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130  QC Quality Control | QC1- Inspect dimensions to dimension sheet Memo | 0.00 0.00 SA 10/12/02 | | | | 1 | | | |
| 140  QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 Q 10.12.7 | | | | 1 | | | |
| 150  HandFXtube Hand Finishing Crosstubes | Crosstubes Chemical Conversion Memo | 0.00 0.00 SAM 10-12-09 | | | | 1 | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Work Order ID 63861

Wednesday, November 17, 2010 10:25:30 A

Page 3

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Revision ID:

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and Stock in kanban rack
Location: LG

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

SAD
10-12-0810/12/09
MF
10-12-08

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NOTE: Date & initial all entries

Picklist Print

Wednesday, November 17, 2010 10:25:35 AM

Page 1

Work Order ID: 63861

Parent Item: D212-664-101TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 11/17/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 removed Polish EC verified by: DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D6005-128 | | Manufactured | No | | | 120 | Each | 32.0000 | 1 | 1 | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|



Crosstube Material



SA 10/12/02

Location

Loc Qty

Loc Code

| | | |
|-------|----|--|
| LG | 32 | |
| 53593 | 5 | |
| 57911 | 27 | |

1

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

| | | | |
|---|--|---------------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 63861 |
| Description: Crosstube Assembly (205/212/412 High Fwd) | | Part Number: | D212-664-141 |
| Inspection Dwg: D212-664-141 Rev: D | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| SIDE A | 0.200 | +/-0.010 | 205 | / | | Vel | SA-5 |
| | R0.063 | +/-0.010 | R0.060 | / | | RG | |
| | 2.740 | +0.005/-0.000 | 2.736 | | / | Mic | CNC-04 |
| | 5.097 | +/-0.030 | 5.097 | / | | Vel | SA-5 |
| | 2.304 | +0.005/-0.000 | 2.300 | | / | Mic | CNC-04 |
| | 2.340 | +0.005/-0.000 | 2.342 | / | | | |
| | 2.398 | +0.005/-0.000 | 2.401 | / | | | |
| | 2.448 | +0.005/-0.000 | 2.450 | / | | | |
| | 2.498 | +0.005/-0.000 | 2.500 | / | | | |
| | 2.549 | +0.005/-0.000 | 2.556 | | / | | |
| | 2.599 | +0.005/-0.000 | 2.604 | / | | | |
| | 2.671 | +0.005/-0.000 | 2.675 | / | | | |
| | 2.701 | +0.005/-0.000 | 2.705 | / | | | |
| SIDE B | 0.200 | +/-0.010 | 205 | / | | Mic | CNC-04 |
| | R0.063 | +/-0.010 | R0.063 | / | | RG | |
| | 2.740 | +0.005/-0.000 | 2.740 | / | | Mic | CNC-04 |
| | 5.097 | +/-0.030 | 5.097 | / | | Vel | SA-5 |
| | 2.304 | +0.005/-0.000 | 2.307 | / | | Mic | CNC-04 |
| | 2.340 | +0.005/-0.000 | 2.349 | | / | | |
| | 2.398 | +0.005/-0.000 | 2.405 | | / | | |
| | 2.448 | +0.005/-0.000 | 2.453 | / | | | |
| | 2.498 | +0.005/-0.000 | 2.503 | / | | | |
| | 2.549 | +0.005/-0.000 | 2.559 | | / | | |
| | 2.599 | +0.005/-0.000 | 2.606 | / | | | |
| | 2.671 | +0.005/-0.000 | 2.676 | / | | | |
| | 2.701 | +0.005/-0.000 | 2.705 | / | | | |
| | 126.514 | +/-0.020 | 126.50 | / | | Tap | SA-01 |

| | | | |
|------------------------|--------------------------------|----------------------------|-----|
| Measured by: SA | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 10/12/02 | Date: 10/12/07 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|-------------|
| A | 05.04.27 | New Issue (P/O D412-664-101) | KJ/JLM | |
| B | 06.03.15 | Tolerance revised for 5.097 per Dwg Rev update | KJ/JLM | |
| C | 07.05.28 | Dwg Rev updated | KJ/JLM | |
| D | 10.02.02 | Dimension 126.514 was 126.51 | KJ | [Signature] |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

| Item | Qty -141 | Qty -141B | Part Number | Description |
|------|-------------|--------------|----------------|---|
| 1 | X | | D212-664-141 | CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD) |
| 2 | | X | D212-664-141B | CROSSTUBE ASSEMBLY (214 HIGH FWD) |
| 3 | 1 | 1 | D6005-128 | CROSSTUBE |
| 4 | 2 | 2 | D2893-1 | SUPPORT |
| 5 | 4 | 4 | D3595-063-450 | RUBBER CUSHION |
| 6 | 4 | 4 | MS21920-25 | CLAMP (OR MS21920-26) |
| 7 | A/R | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- 7) WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *63864*
DS 10-11-17

RELEASED
2009-10-29
MT

| | | | |
|------------|--|---|--------------|
| D | REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4 | RF | 09.09.30 |
| C | REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS | PH | 07.03.08 |
| B | ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES | PH | 05.02.04 |
| A | NEW ISSUE | PH | 00.12.12 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>PH</i> | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>PH</i> | DRAWING NO. | REV. D |
| MFG. APPR. | <i>DS</i> | D212-664-141 | SHEET 1 OF 4 |
| APPROVED | <i>DS</i> | TITLE | SCALE |
| DE APPR. | <i>DS</i> | XTUBE ASS'Y (205/212/412 HI FWD) | NTS |
| DATE | 09.09.30 | COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

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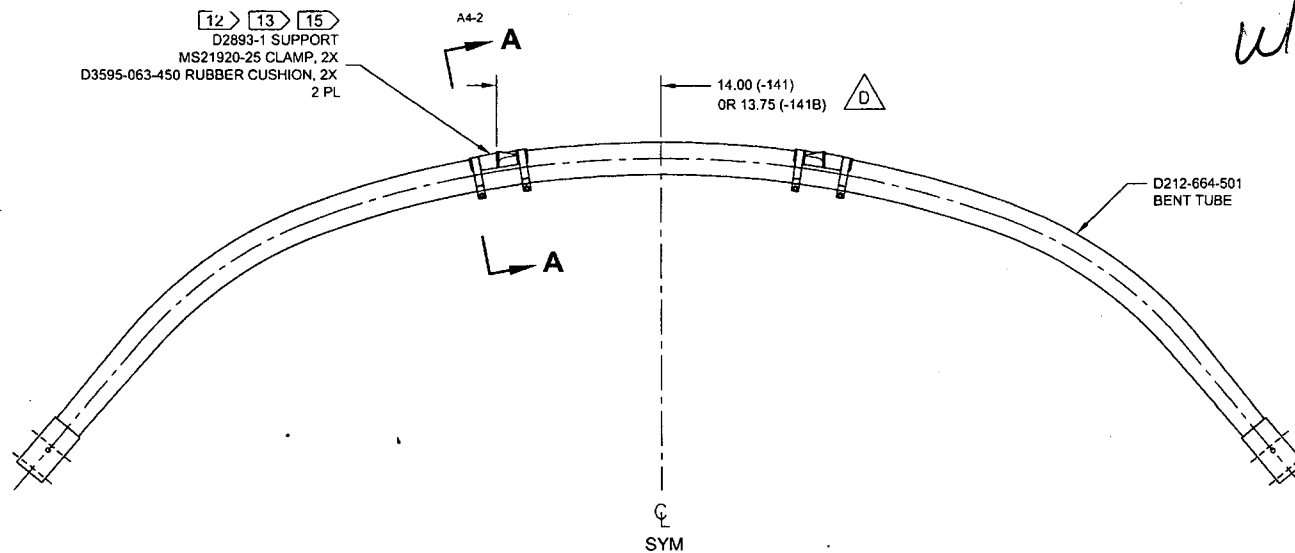
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

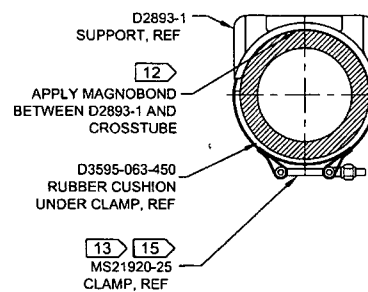
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NOTE: Date & initial all entries

W043861



D212-664-141/-141B
ASSEMBLY DETAIL



SECTION A-A
SCALE 4X D5-2

RELEASED
2009-10-29

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 92 | DRAWING NO. | REV. D |
| MFG. APPR. | 13 | D212-664-141 | SHEET 2 OF 4 |
| APPROVED | 14 | TITLE | SCALE |
| DE APPR. | 14 | XTUBE ASS'Y (205/212/412 HI FWD) | NTS |
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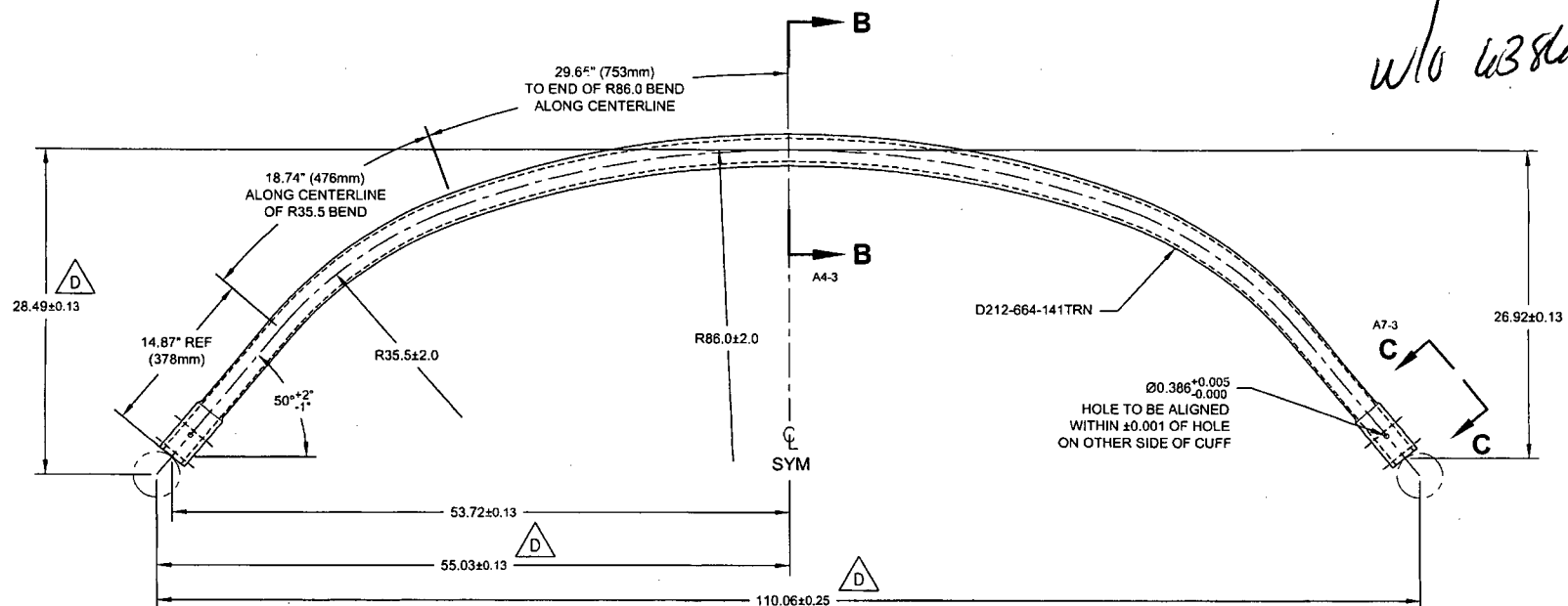
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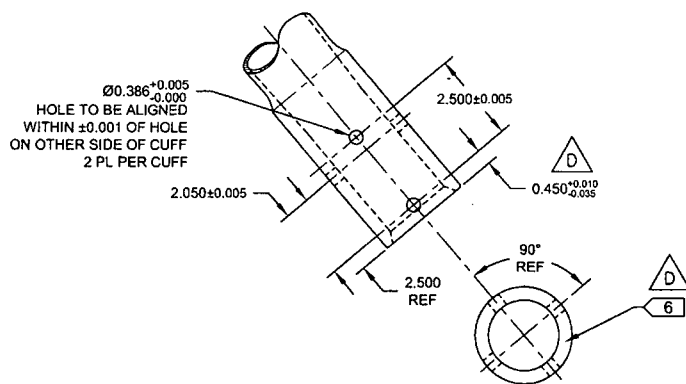
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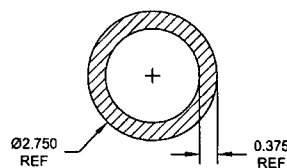
W/O 43861



D212-664-501
BENDING AND DRILLING DETAIL



VIEW C-C: CUFF DETAIL C2-3
SCALE 3X



SECTION B-B C4-3
SCALE 4X

RELEASED
2009-10-29

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | Q | DRAWING NO. | REV. D |
| MFG. APPR. | AS | D212-664-141 | SHEET 3 OF 4 |
| APPROVED | AD | TITLE | SCALE |
| DE APPR. | TH | XTUBE ASS'Y (205/212/412 HI FWD) | NTS |
| DATE | 09.09.30 | <small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

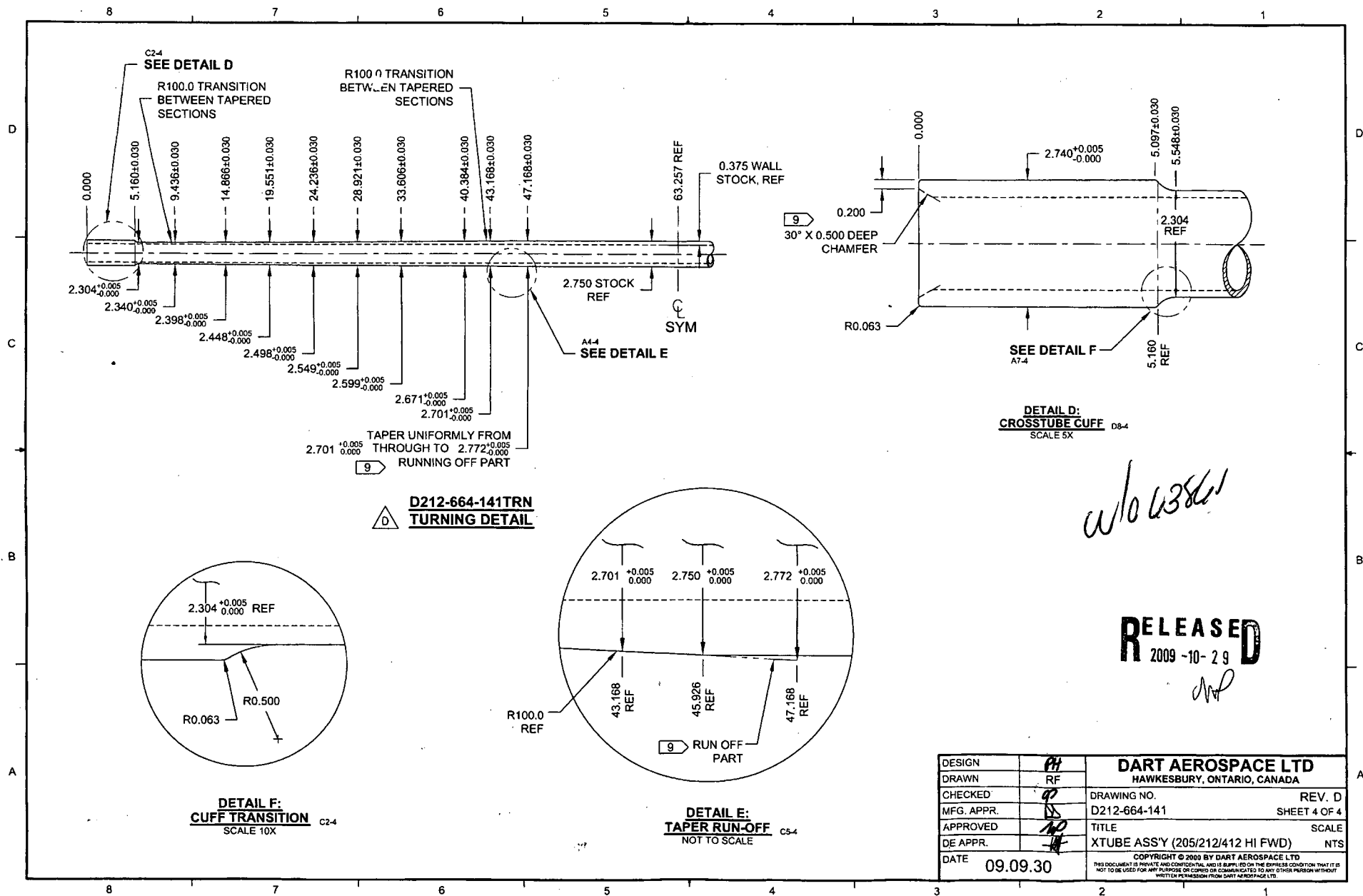
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries